

# Work Order ID 67389 - 2

Thursday, March 17, 2011 11:51:55 AM

Page 1

Item ID: D2230-1

Revision ID:

Item Name: Lug

Start Date: 3/17/2011

Start Qty: 100.00

Required Date: 3/25/2011

Req'd Qty: 100.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut D2423 extrusion to 0.82"

Batch:

cut @ Metec

110



HAAS

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FA927

DWG REV:

FOLIO REV:

(Click for crack while loading into the machine.)

2- deburr rough edges

Issue PO 13674

Metec  
Machine per drawing D2230 Rev G



Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



PL 11-03-17

# Work Order ID 67389

Thursday, March 17, 2011 11:51:55 AM

Page 2

Item ID: D2230-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug

Start Date: 3/17/2011 Start Qty: 100.00

Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 100.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120  
QC  
Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

*Review + Inspect*  
*for trust damage*

0.00

*4/3/31 (37)*

130  
QC  
Quality Control

QC5  
QC8- Inspect parts - second check

0.00

Memo

0.00

*8 u/03/31*

*counted*  
*(437)*

140  
HandFinish  
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

*37 BR 11-3-31.*

# Work Order ID 67389

Thursday, March 31, 2011 12:33:36 PM



Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/17/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

37 d M 11/03/31

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 11/5951

Memo

0.00

Powder Coating

START TIME: 9:40

OVEN TEMPERATURE: 320°

FINISH TIME: 10:10

37. BR 11-4-4

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

37 d M 11/04/06

# Work Order ID 67389

Thursday, March 31, 2011 12:33:36 PM



Page 4

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/17/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

180

Identify as per dwg & Stock Location: 6A

0.00



Packaging

Memo

w/ 67584

0.00

Packaging

ES 11/04/12 (370)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/12

11.04.12

# Picklist Print

Thursday, March 17, 2011 11:51:52 AM

Page 1

Work Order ID: 67389

Parent Item: D2230-1

Parent Item Name: Lug



Start Date: 3/17/2011

Required Date: 3/25/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ID: 00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			110	f	477.0414	0.0683	7.189474			



Lug Extrusion



## Location

MAT006

## Loc Qty

477.0414265

180

16.1914265

280.85

## Loc Code

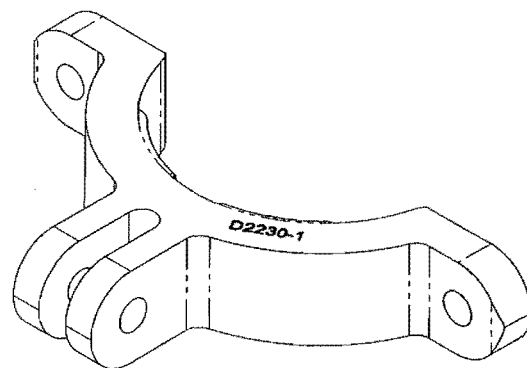
43722  
45800  
63005

11-03-17

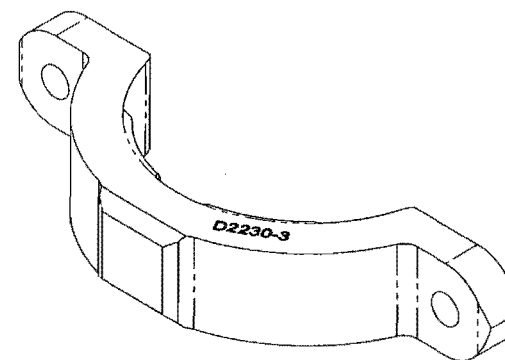
D2230-1 P

4/13/31

37



**D2230-1 MOUNTING LUG**



**D2230-3 MOUNTING LUG**

*w/o 67389*

**RELEASED**  
07/06/25/11

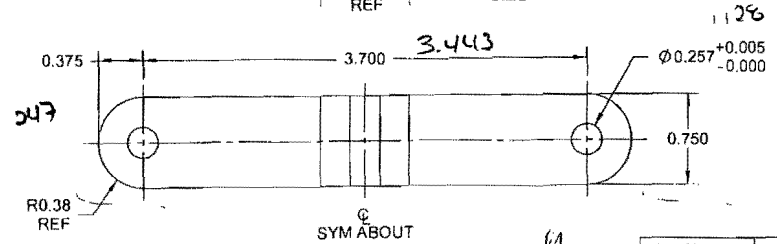
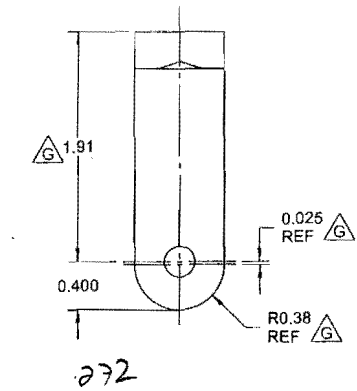
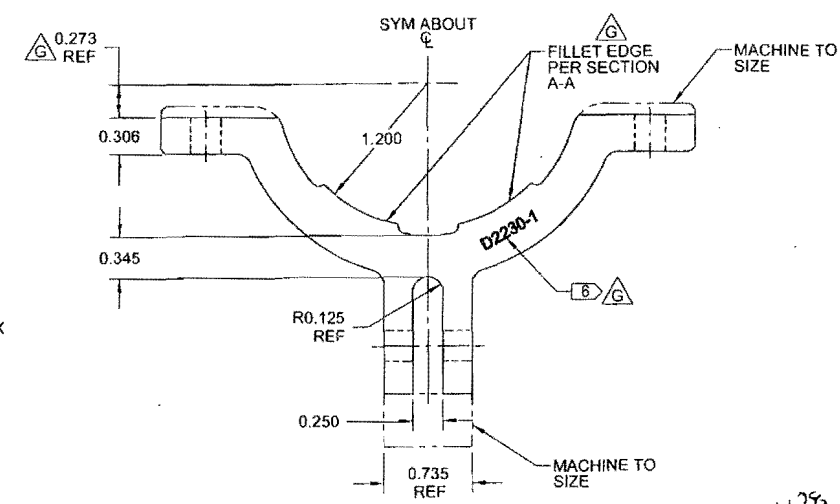
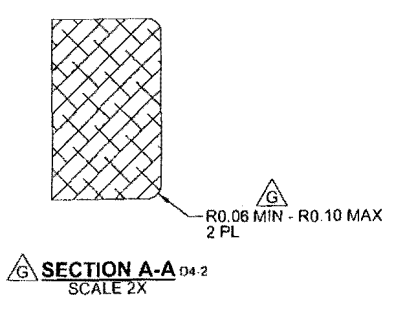
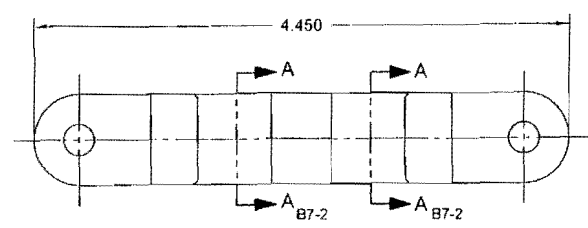


**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs  
-3: 0.14 lbs

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN: R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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8 7 6 5 4 3 2 1



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09/06/25

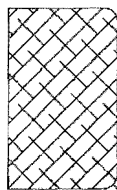
**D2230-1 MOUNTING LUG**

64381

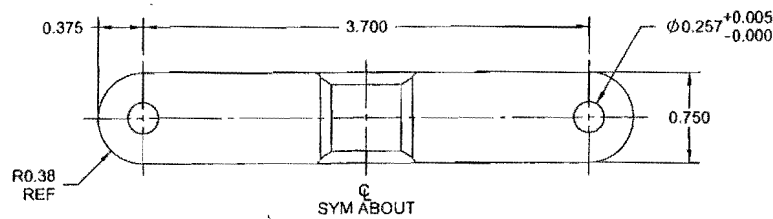
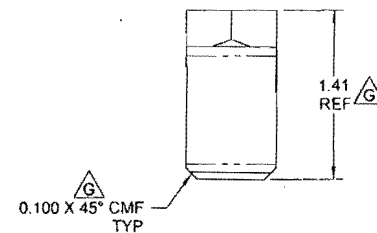
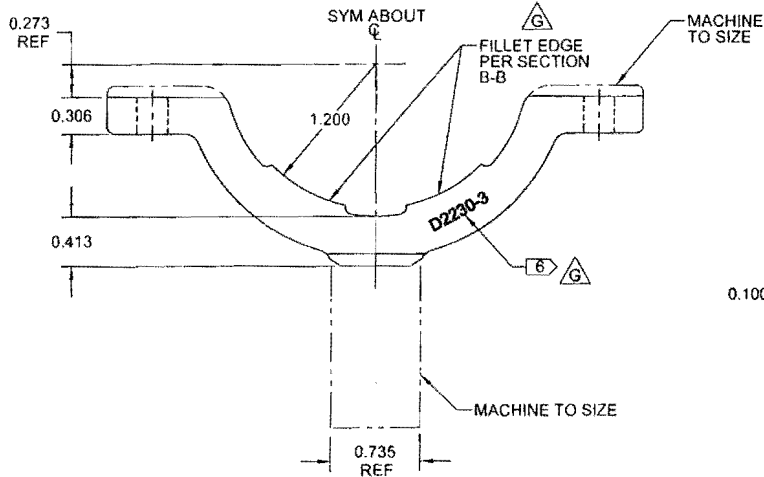
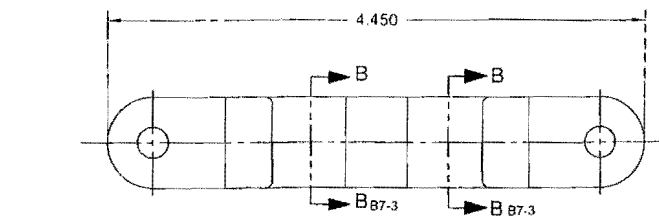
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DRAWN	AJS		
CHECKED		DRAWING NO. <b>D2230</b>	REV. G
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DATE	09.01.16		

8 7 6 5 4 3 2 1

**SECTION B-B** D4-3  
SCALE 2X



R0.06 MIN - R0.10 MAX  
2 PL



**D2230-3 MOUNTING LUG**

67389

**RELEASED**  
09/06/2014

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0  
Tel: (613) 678-3957  
Fax: (613) 678-3956

Delivery Slip No.: 17853  
Date: Mar 30, 2011  
Page: 1

<b>Sold to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	<b>Ship to:</b>  Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 13674	<b>Sold By:</b> Walz, Christian D.
<b>Shipped By:</b> your truck	<b>Ship Date:</b>

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	37	
Received by _____		Thank you for your order!		



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
37	D2230-1	Mounting Lug	13674

MATERIAL: supplied by DART D2423 B63005

S 11/03/13

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in dark ink, appearing to read "Shigi Walz", is written over the printed name.

Shigi Walz

Vankleek Hill, March 30, 2011